

Work Order ID 57981

April 21, 2010 10:06:10 AM



Page 1

Item ID: D130-780-011

Accept



Setup Start



Revision ID:

Item Name: Aft LH Door Hinge

Stop



Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

RF

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9502

A

IIN-D130-780

B

100

0.00



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D130-780-011
CHG 003

Sub 1/28

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-4-21 *SL*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57981

April 21, 2010 10:06:10 AM



Page 2

Item ID: D130-780-011

Accept



Setup Start



Revision ID:

Item Name: Aft LH Door Hinge

Stop



Start Date: 21/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

S 10/04/08



QC

Memo

0.00

Quality Control



130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-011

Location: _____

PPP rev: _____

10-4-28 SF

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/28 MF
10-4-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:06:15 AM

Page 1

Work Order ID: 57981

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D130-780-015		Manufactured	No			110	Each	1.0000	1.0000			



Closeout Installation *at 17001*

10-4-27 SP

Warehouse
Location

Main Warehouse

FG

53145

110

1

1

Each

10.0000

1.0000



10-4-27 SP

D3552-13



Door Prop

Warehouse
Location

Main Warehouse

ST272A

56392

110

10

10

Each

100.0000

1.0000



10-4-27 SP

D3892-1



Seal

Warehouse
Location

Main Warehouse

ST416

47330

100

100

1X

cut to 5"

*measured
81014162*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:06:15 AM

Page 2

Work Order ID: 57981

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3813-041 Hinge Assembly, Upper Door		Manufactured	No			110	Each	7.0000	1.0000		10-4-27 SP	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST090

7

45727

1

50349

1

53043

5

D3813-043

Manufactured No

110

Each

5.0000

1.0000

Hinge Assembly, Lower Door

10-4-27 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST090

5

53044

5

D3814-1

Manufactured No

110

Each

11.0000

1.0000

Hinge, Upper Airframe

10-4-27 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST091

11

45673

1

50119

4

50261

6

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:06:15 AM

Page 3

Work Order ID: 57981

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC



IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3814-3  Hinge, Lower Airframe		Manufactured	No			110	Each	17.0000	1.0000 		10-4-27 SP	

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST091	17	
50120	5	
50475	12	

Manufactured No

110 Each 18.0000 2.0000


10-4-27 SP

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST091	18	
45675	18	

Manufactured No

110 Each 20.0000 4.0000


10-4-27 SP

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST091	20	
52930	20	

SP

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:06:15 AM

Page 4

Work Order ID: 57981

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC



IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3817-041  Anchor Nut Plate		Manufactured	No			110	Each	20.0000	1.0000 		10-4-27 SP	

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST092

20

50381

20

Purchased

No

110

Each

1,013.000

2.0000


10-4-27 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST350

1013

105057

1013

Purchased

No

110

Each

72.0000

3.0000


10-4-27 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST351

72

113539

22

114227

50

3

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:06:15 AM

Page 5

Work Order ID: 57981

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN310-41		Purchased	No			110	Each	42.0000	2.0000			
NUT												

10-4-27 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST314 22

113845 22

Main Warehouse

ST349 20

114341 20

Purchased No

110 Each 56.0000 2.0000

10-4-27 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST359 56

112794 6

113121 20

113288 30

2

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-21, 2010 10:06:15 AM

Page 6

Work Order ID: 57981

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN970-4 Washer		Purchased	No			110	Each	135.0000	2.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST349

135

112991

135

110

Each

1,089.000

5.0000

2

10-4-27 SP

MS2104215

Purchased

No

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1089

113537

105

113644

984

110

Each

117.0000

2.0000

2

10-4-27 SP

MS24665-2-12

Purchased

No

COTTER PIN

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST309

117

111499

117

2

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:06:15 AM

Page 7

Work Order ID: 57981

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24694-S46 SCREW		Purchased	No			110	Each	85.0000	3.0000		10-4-27	

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST289

85

111499

85

NAS1149D0363J

Purchased

No

110

Each

1,694.000 8.0000

Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST298

1694

113288

18

114292

1676

NAS1149D0463J

Purchased

No

110

Each

1,236.000 2.0000

Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST298

1236

113706

1236

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:06:15 AM

Page 8

Work Order ID: 57981

Parent Item: D130-780-011

Parent Item Name: Aft LH Door Hinge

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3622-1 Ball Stud		Manufactured	No			110	Each	25.0000	2.0000			



10-21-27sl

Warehouse
Location

Main Warehouse

ST074

25

55199

25

Manufactured No

110

Each

23.0000

1.0000



2

10-4-27sl



Bracket

Warehouse
Location

Main Warehouse

ST092

23

42079

1

45732

22

Purchased No

110

Each

442.0000

2.0000



1

10-4-27 sl



Nut

Warehouse
Location

Main Warehouse

ST300

442

113523

26

113537

116

114108

200

114437

100

2

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 21, 2010 10:06:15 AM

Page 9

Work Order ID: 57981



Parent Item:* D130-780-011



Parent Item Name: Aft LH Door Hinge

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149D0563J		Purchased	No			110	Each	1,873.000	2.0000			



Washer



10-4-27

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST298

1873

113524

44

113706

1829

8

April 21, 2010 10:06:15 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X				1			D130-780-041	SPACEPOD™ LH, EC 130 B4
	X			1			D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X		1			D130-780-043	DOOR ASSEMBLY, LH
	1		X	1			D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

© COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043 /	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

• COPYRIGHT © 2008 BY DART AEROSPACE LTD •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: B

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION
REF. TCCA STC: SH93-88
REF. FAA STC: SR00098NY
REF. EASA.IM.R.S.01292

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH Sliding Door **REFERENCE ONLY**

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-13	DOOR PROP

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

-011		
X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
1	D3552-13	DOOR PROP

- 1) Remove the D3552-7 door prop from the ball studs
- 2) Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
- 3) Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
- 4) Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.

Weight and Balance change associated with this DSI is negligible.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # C1-O-01	
APPROVED	
BY: <i>[Signature]</i>	D. SHEPHERD (DE # 02)
DATE: 10.02.03	
CERT. NO.: SH93-88	
ISSUE NO.: 6	

A	NEW ISSUE	BY: <i>[Signature]</i>	10.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9502	REV. A
MFG. APPR.	N/A	SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REPLACEMENT DOOR PROP NTS	
DATE	10.02.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries